

SMALL FAB

6910



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM632V3008102-6

Job Sheet 180312



Part No: RBEM632V3008102-6

Job Qty: 2 ea

DAS

21

9-89

Part Name: Support Ring Assembly



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 7/16/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM632V3008102 Rev. C IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/16/18	7/16/18	0.00	0.00	Start Up Small Fab-4		MCC
100	Small Fab	2 pcs	7/16/18	7/16/18	0.00	0.10	Small Fab-9		MCC
110	QC	2 pcs	7/16/18	7/16/18	0.00	0.00	QC5		MCC
130	Packaging	2 pcs	7/16/18	7/16/18	0.00	0.00	Packaging3-2		MCC
140	QC21-SA	2 Ea	7/16/18	7/16/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 100 - Assemble as per DWG. See note 9.
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBEM632V3008102-7	Support Ring Weldment	2 Ea (1 ea)	90-Start up Operation	5099856
90965A200	SS Flat Washer for M10 Screw	2 (1 ea)	100-Small Fab	5091256
94150A358	SS Hex Nut M10 x 1.5mm	2 (1 ea)	100-Small Fab	5091257

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBEM632V3008102-7	2	0	0
100-Small Fab	90965A200	2	0	0
	94150A358	2	0	0

Part Specifications

Specifications could not be found.

Plex 7/4/18 1:07 PM dart.logan.david



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Container No: S099989



Part: RBEM632V3008102-6

Job No: 180312

Serial No/Batch: S099989

Revision: C

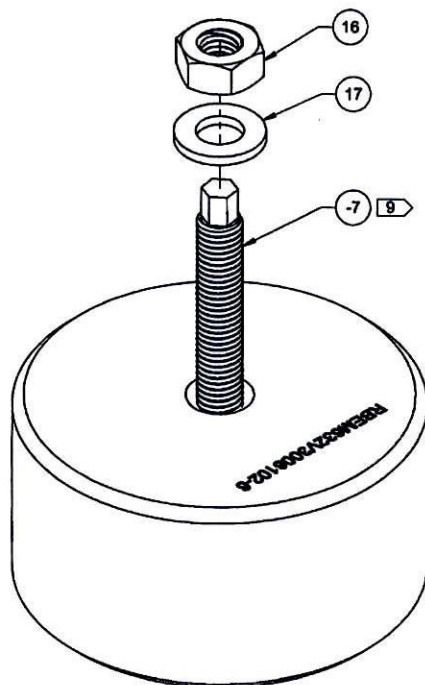
Inspector:

Exp Date:

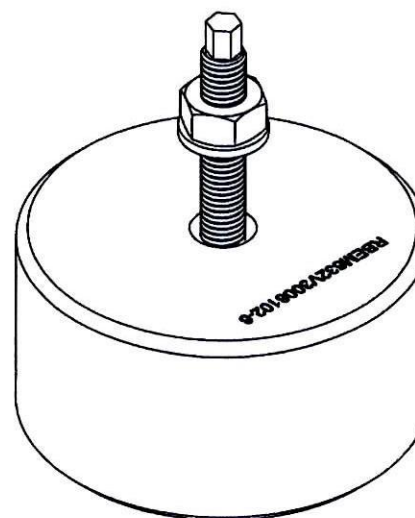
Instructions:

Date: 08/08/18

ITEM #	QTY	PART #	PART TITLE
-7	1	RBEM632V3008102-7	SUPPORT RING WELDMENT
16	1	McMaster#84150A358 OR EQUIV	SS HEX NUT M10 x 1.5mm
17	1	McMaster#90965A200 OR EQUIV	SS FLAT WASHER FOR M10 SCREW



RBEM632V3008102-6 SUPPORT RING ASSY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 180312

20180710

72

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 6) BREAK SHARP EDGES: N/A

- 7) IDENTIFICATION: N/A

- 8) ASSEMBLE AS SHOWN

- 9) APPLY LOCTITE NICKEL BASED ANTI SEIZE ON THREADS OF ITEM -7 THEN ASSEMBLE WITH ITEM 16

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. C
MFG. APPR.	DP	RBEM632V3008102	SHEET 7 OF 13
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	6/6/2018	OUTPUT FLANGE SEAL EXCHANGE	NTS
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